



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

M. Lee
MARCH 5/20

D5805-9

Job Sheet 207535



POSITIVE
RECALL

Part No: D5805-9

Job Qty: 12 pcs

Part Name: Stud



Part Weight: 0 lbs

Job Created: 2/27/20

Due Date: 3/27/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Priority: Medium

N/A

LIMITED RELEASE

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	12 pcs	3/27/20	3/27/20	0.50	0.80	Hardinge - 1		<i>JB 20-03-07</i>
110	QC 2	12 pcs	3/27/20	3/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		<i>JB 20-03-07</i>
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S261612



Part: D5805-9

Job No: 207535

Serial No/Batch: S261612

Revision: REV.A

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/07/20

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9-89

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Plex 3/5/20 7:17 AM Dart.lajeunesse.marie

120	QC 8	12 pcs	3/27/20	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	12 pcs	3/27/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

3/5/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 QC 21 - SA	12 pcs	3/27/20	0.00 0.00	Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - 1-Machine as per folio F _____ FOLIO REV: _____ DWG REV: A 2-Deburr
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.625	M1018R0.625	1.8276 ft (.1523 ea)	100-Hardinge - 1	5000799

.153

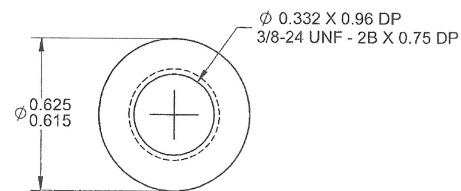
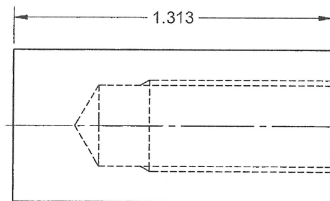
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M1018R0.625 0.750" B.A	2	0	0

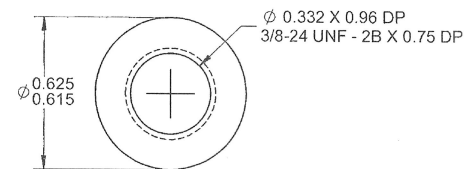
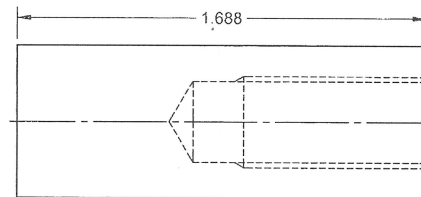
Part Specifications

Specifications could not be found.

Plex 3/5/20 7:17 AM Dart.lajeunesse.marie



D5805-7 STUD
(DERIVED FROM AERO DESIGN P/N 76423-05)



D5805-9 STUD
(DERIVED FROM AERO DESIGN P/N 76423-06)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1018/1025 STEEL ROUND BAR
PER MIL-S-7097 OR ASTM A108
REF DART SPEC M1018-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.09 lbs
-9: 0.12 lbs

RELEASED
2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5805	SHEET 6 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	ATTACHMENT HOOP	NTS
DATE	20.01.13	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD

Work Order:

207535

Description: ATTACHMENT HOOP STUD

Part Number:

D5805-9

Inspection Dwg: D5805

Rev: A

Page 1 of 1

INSPECTION SHEET

[illegible]

DAS
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Measured by:	TB
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9-89

Checked by:

9-89

QC Inspector:

Date: 20.03.07

Date:	20/3/17
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Date:

Engineering Approval:
(If necessary)

Date:

Rev	Date	Change	Revised by	Approved
A	7-Mar-20	New Issue	MG	



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO37858

Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

PO No: PO37858
PO Date: 9/25/17
Due Date: 10/6/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: net 30
Freight Terms:
Special Comments:

Items											
Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	M1018R2.250	-	M1018R2.250 : MATERIAL: AISI 1018-1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	3 ft	0 ft 3x	3 ft	\$12.206666/ft	\$36.62
2	M1018R0.750	✓	M1018R0.750 : MATERIAL: AISI 1018-1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	20 ft	0 ft 2x B.11	20 ft	\$1.169/ft	\$23.38
3	M1018B1.000X06.000	✓	1010-1025 Steel Bar 1.000 X 6.000 : MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR OR CSA G40-21 38W/44W/50W/60W/70W CSA G40-21 OR 38W/44W/50W/60W/70W		Firmed	10/6/17	6 ft	0 ft 6x	6 ft	\$30.42/ft	\$182.52
4	M304R.500	✓	304 SS roundbar .500 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE		Firmed	10/6/17	36 ft	0 ft 36x	36 ft	\$1.9072222/ft	\$68.66
5	M6061T6R1.375	✓	6061-T6 Round Bar 1.375" : MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117 4128/4115/4116 OR QQ-AA-200/8 OR AMS-QQ-A-		Firmed	10/6/17	12 ft	0 ft 12x	12 ft	\$5.6841666/ft	\$68.21



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37858

Purchase Order Date 9/25/2017

PO Print Date 9/25/2017

Page Number 1 of 6

Order From :

VC-CAM002

Ship To : DART AEROSPACE LTD

ACIER OUELLETTE INC.
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
SEP 25 2017

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	M1018R2.250	M1018R2.250	10/6/2017 Yes 10/6/2017		3.00 f	\$12.21	\$36.62
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MATERIAL: AISI 1018-1025 ROUND BAR AS PER
MIL-S-7097 OR ASTM A108

Line Total: \$36.62

2	M1018R0.750	M1018R0.750	10/6/2017 Yes 10/6/2017		20.00 f	\$1.17	\$23.38
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MATERIAL: AISI 1018-1025 ROUND BAR AS PER
MIL-S-7097 OR ASTM A108

recd. 18.11
10-17

Line Total: \$23.38

PO Instructions: QUOTATION: SOU0059954

Note:

9/25/2017



ARANA Y LUPARDO, 2
48490 UGAO-MIRAVALLES/VIZCAYA (SPAIN)
Tfno.: 946480211
Fax: 946480128
Email: calpradera@calibradospradera.es
www.calibradospradera.es

TRA 1589 48490

3P.

CERTIFICADO DE CALIDAD/QUALITY REPORT

De acuerdo a /Made according to:

EN 10204/DIN 50049

3.1

Nº CERTIFICADO / CERTIFICATE NR.: 47862

ALBARAN 47862 Delivery Note Nr.	CLIENTE LES ACIERS TRANSPEC (1997) LTÉE CUSTOMER
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Norma : EN 10277

Productos Calibrados de acero. Condiciones técnicas de suministro.

Norm :

Bright steel products. Technical delivery conditions.

PRODUCTO SOLICITADO / PRODUCT ACCORDING ASTM A108

Nº PEDIDO Purchase Order	DESCRIPCIÓN Description	KGS.	TOLERANCIA TOLERANCE	OF	MEDIDA Measurement
VI 46700	12L14 RED. ESTIRADO 25,40 (1")	1.004	-0,051	202437	25,40
PAR-47782	1018 RED. ESTIRADO 25,00	1.822	-0,051	139261	25,00
PAR-47785	1018 RED. ESTIRADO 25,00	3.982	-0,051	139283	25,00
PAR-47786	12L14 RED. ESTIRADO 12,70 (1/2")	1.000	-0,051	137659	12,70
PAR-47795	1018 CUA. ESTIRADO 31,75 (1 1/4")	1.224	-0,160	136439	31,75
SM-47572	1018 RED. ESTIRADO 15,88 (5/8")	1.008	-0,051	916391	15,88
SM-47572	1018 RED. ESTIRADO 19,05 (3/4")	1.134	-0,051	139479	19,05
OU-47832	12L14 RED. ESTIRADO 12,70 (1/2")	1.000	-0,051	137659	12,70
OU-47832	1018 RED. ESTIRADO 19,05 (3/4")	1.190	-0,051	139625	19,05
PAJ-48073	1018 CUA. ESTIRADO 9,53 (3/8")	983	-0,090	915990	9,53
PAJ-48073	1018 RED. ESTIRADO 15,88 (5/8")	1.150	-0,051	916216	15,88
PAR-48154	1018 CUA. ESTIRADO 6,35 (1/4")	784	-0,090	915673	6,35
PAR-48154	1018 RED. ESTIRADO 7,94 (5/16")	1.090	-0,051	916609	7,94
PAR-48154	1018 RED. ESTIRADO 22,23 (7/8")	3.034	-0,051	139773	22,23
PAR-48154	12L14 RED. ESTIRADO 15,88 (5/8")	824	-0,051	916509	15,88
MJP-47896	12L14 RED. ESTIRADO 25,40 (1")	784	-0,051	202437	25,40
PAR-48154	1018 RED. ESTIRADO 28,58 (1 1/8")	744	-0,051	916104	28,58
MN-47094	1018 RED. ESTIRADO 22,23 (7/8")	1.012	-0,051	139824	22,23

Composición química de la colada / Chemical Analysis of Heat

MEDIDA Measurement	OF	COLADA Cast Nr.	% C	% Cr	% Cu	% Mn	% Mo	% N	% Ni	% P	% Pb	% S	% Si
25,40	0,00	202437	0,060	0,086	0,014	1,130	0,006	0,000	0,023	0,063	0,300	0,310	0,003
25,00	0,00	139261	0,150	0,000	0,000	0,630	0,000	0,000	0,000	0,007	0,000	0,014	0,125
25,00	0,00	139283	0,150	0,000	0,000	0,630	0,000	0,000	0,000	0,007	0,000	0,014	0,125
12,70	0,00	137659	0,067	0,025	0,016	1,057	0,004	0,000	0,018	0,053	0,192	0,283	0,018
31,75	0,00	136439	0,159	0,000	0,000	0,806	0,000	0,000	0,000	0,018	0,000	0,024	0,183
15,88	0,00	916391	0,145	0,000	0,000	0,775	0,000	0,000	0,000	0,013	0,000	0,027	0,157
19,05	0,00	139479	0,151	0,000	0,015	0,841	0,000	0,004	0,000	0,012	0,000	0,029	0,204
12,70	0,00	137659	0,067	0,025	0,016	1,057	0,004	0,000	0,018	0,053	0,192	0,283	0,018
19,05	0,00	139625	0,151	0,000	0,015	0,841	0,000	0,004	0,000	0,012	0,000	0,029	0,204
9,53	0,00	915990	0,140	0,000	0,198	0,760	0,000	0,000	0,000	0,016	0,000	0,033	0,242
15,88	0,00	916216	0,145	0,000	0,000	0,775	0,000	0,000	0,000	0,013	0,000	0,027	0,157
6,35	0,00	915673	0,150	0,000	0,000	0,770	0,000	0,000	0,000	0,007	0,000	0,026	0,225
7,94	0,00	916609	0,170	0,000	0,000	0,730	0,000	0,000	0,000	0,017	0,000	0,018	0,160
22,23	0,00	139773	0,173	0,000	0,132	0,817	0,000	0,003	0,000	0,010	0,000	0,022	0,218
15,88	0,00	916509	0,068	0,033	0,020	1,134	0,004	0,000	0,022	0,055	0,329	0,290	0,071
25,40	0,00	202437	0,060	0,086	0,014	1,130	0,006	0,000	0,023	0,063	0,300	0,310	0,003
28,58	0,00	916104	0,155	0,000	0,000	0,635	0,000	0,000	0,000	0,013	0,000	0,016	0,137
22,23	0,00	139824	0,173	0,000	0,132	0,817	0,000	0,003	0,000	0,010	0,000	0,022	0,218

Características mecánicas / Mechanical properties

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M1018R0.750

PO / BATCH NO.: 637858/500799

DATE: OCT 18 2017

MATERIAL CERT REC'D: yes

THICKNESS ORDERED: .750

QUANTITY RECEIVED: 19'

THICKNESS RECEIVED: .750

QUANTITY INSPECTED: 19'

SHEET SIZE ORDERED: N/A

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL PER M-DRAWING	(Y)	N	45m 4108
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT REF # TO LINK CERT	(Y)	N	HT #139625
CORRECT MATERIAL IDENTIFICATION	(Y)	N	5000799
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	WEBSTER

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 5</u> DATE: <u>OCT 18 2017-89</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in